

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022990**Date Inspected:** 23-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

**Bay 1**

This QA inspector observed ZPMC in process of FCAW welding Bike Path Handrail sub-assemblies. ZPMC QC inspector Li Wei Lin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Tian Lei as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- Bike Path Handrail Sub-assembly

WPS-B-P-2112

Welder- 054456

2F/FCAW

**Bay 4**

This QA inspector performed a random observation for the OBG. During the observation performed it was noted ZPMC was in process of welding and heat straightening on traveler rail assemblies to correct distortion after welding. ZPMC CWI inspector Tian Lei was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the

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following location;

WR20795

Weld- 3025TR1-003-011

WPS-345-SMAW-1G(1F)-Repair

Welder- 068764

2G/FCAW(ESAB)/CJP

WR20794

Weld- 3025TR1-001-019

WPS-345-SMAW-1G(1F)-Repair

Welder- 068764

2G/FCAW(ESAB)/CJP

Heat Straightening

HSR1 (B) 10291

3007TR2-001, 3022TR1-001, 3010TR1-002, 3025TR1-001, 3025TR1-002, 3025TR1-003, 3023-TR1-001, 3023TR1-002, 3023TR1-003, 3009TR1-001, 3020TR1-001, 3026TR1-001

Bay 14 (14E)

UT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08913 from ZPMC for QAUT verification for segment 14E. This QA inspector performed ultrasonic test (UT) verification, after ZPMC had performed their UT inspection of the following locations.

Item 5

SEG3019D-235, 239, 244, 248, 252, 256, 264, 268, 287, 291, 295, 299, 303, 307, 311

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 04-23-2011 for additional information.

The following digital picture illustrate stiffener to floorbeam CJP weld testing.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

“As noted within the contents of this report.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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